

Work Order ID 63119

Thursday, October 21, 2010 1:13:10 PM



Page 1

Item ID: D3826-041

Accept



Setup Start



Revision ID:

Item Name: Rib / Gusset Assembly

Stop



Start Date: 10/21/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 10/28/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10/10/21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3826	Rev B								
100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	I- use DT9434 to assemble D2325 support gusset together□2- locate D2325 on rib and weld as per dwg D3826□ A/R ER316 S.S. Rod Batch: 1114649								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	Memo	0.00							
QC									
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
QC									
Quality Control									

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location: _____

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp*Basket coll*

Memo

0.00

10/11/25 (6)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*10/11/26 JJ**JF
10-11-25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 63119



Parent Item: D3826-041



Parent Item Name: Rib / Gusset Assembly

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2235-1 		Manufactured	No				Each	14.0000	1	6		<i>10/11/24</i>	

Basket Rib 													

Location

WA

Loc Qty

Loc Code

D3929-041 		Manufactured	No				Each	5.0000	1	6		<i>10/11/24</i>	
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Location

WA

Loc Qty

Loc Code

D3929-042 		Manufactured	No				Each	0.0000	1	6		<i>10/11/24</i>	
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Location

62362

Loc Qty

Loc Code

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

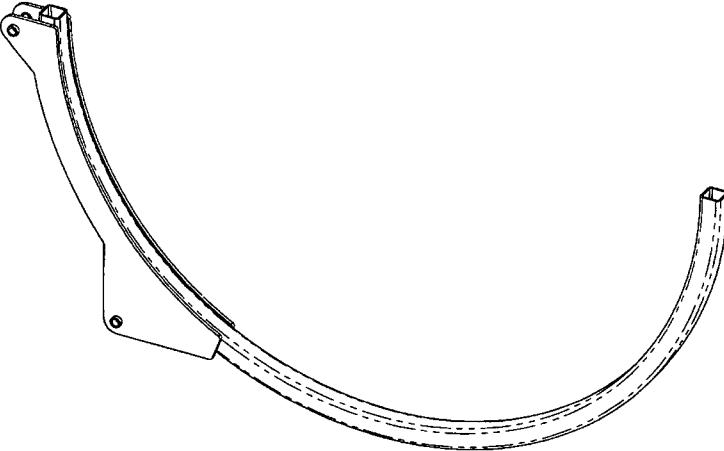
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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8 7 6 5 4 3 2 1

ITEM	QTY. -041	P/N	DESCRIPTION
1	<input checked="" type="checkbox"/>	D3826-041	RIB/GUSSET ASSY
11	<input type="checkbox"/>	D2235-1	RIB
12	<input type="checkbox"/>	D3929-041	GUSSET ASSEMBLY
13	<input type="checkbox"/>	D3929-042	GUSSET ASSEMBLY

B



D3826-041 RIB/GUSSET ASSY

C
B
A

C
B
A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 6319
01/01/08

RELEASED
01/01/08

B	D3929-041/042 WERE D2325 (ZN D3-1 & ZN D6-2). UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.			MB	09.04.16
A	NEW ISSUE			MB	08.09.23
REV.	DESCRIPTION			BY	DATE
DESIGN	<i>b</i>			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>b</i>				
CHECKED	<i>b</i>				
MFG. APPR.	<i>b</i>			REV. B	
APPROVED	<i>b</i>			SHEET 1 OF 2	
DE APPR.	<i>b</i>			TITLE	
DATE	09.04.16			SCALE	
				NTS	
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8 7 6 5 4 3 2 1

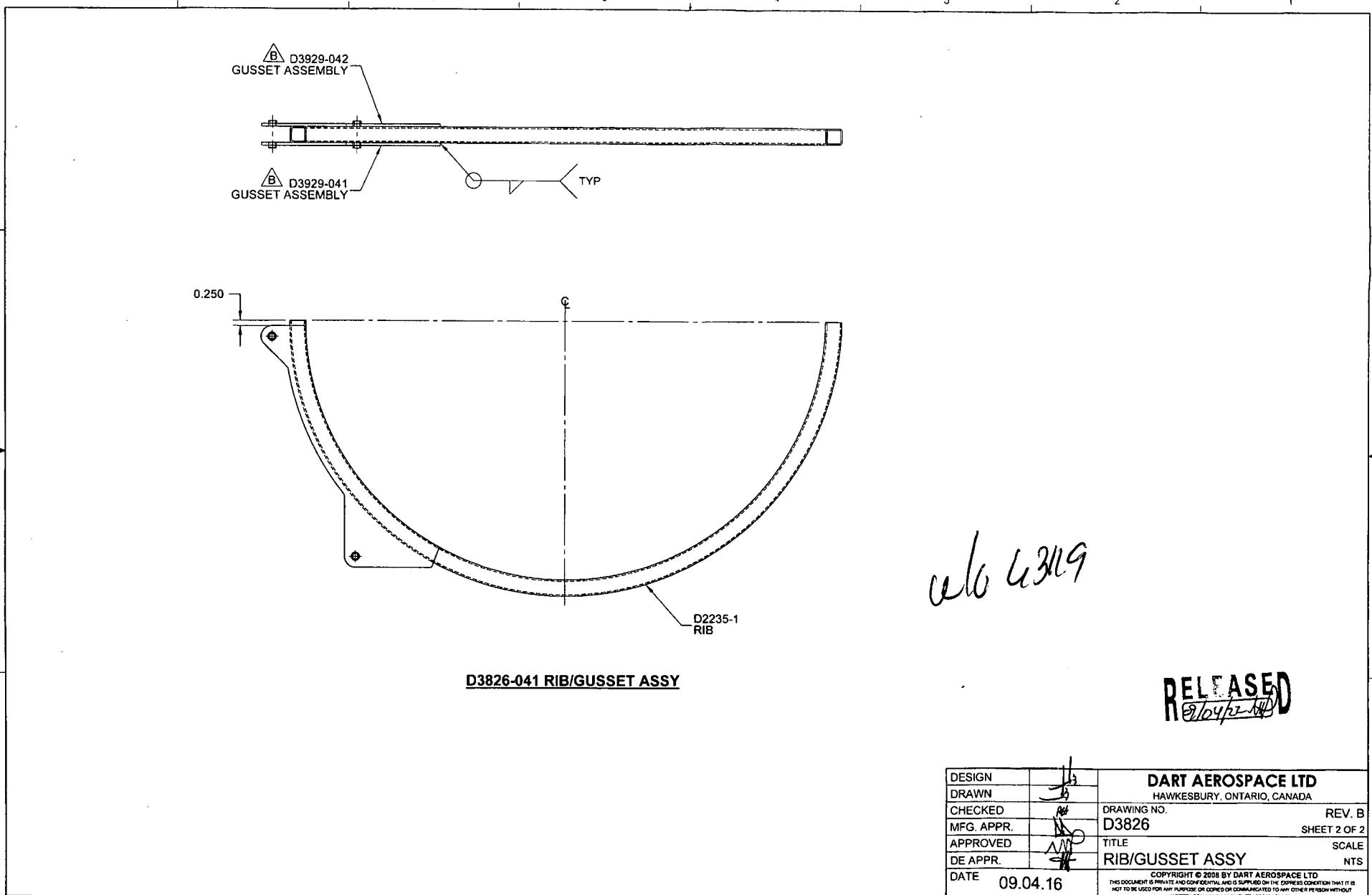
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